

Date: Wednesday, 11/22/2006 1:39:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT	
Job Number	: 29647B		Part Number	: D32782	
Estimate Number	: 10462		Drawing Number	: D3278 REV. B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/22/2006	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/29/2006	
Previous Run	: 29236B		Qty:	30	
Written By	: <u>JK</u> 06/11/22		Um:	Each	
Checked & Approved By			split		
Comment	: Est:A 04/04/19 New issue KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"		
Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: <u>M19295</u> <u>mk 07/01/08</u> <u>52</u>				
2.0	SHEAR <u>SAW</u>	SHEAR		
Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <u>mk 07/01/08</u> <u>52</u>				
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 <u>JK/J.F. 07/01/10</u> <u>30</u>				
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JK/J.F. 07/01/10</u> <u>30</u>				
5.0	QC8	SECOND CHECK		
Comment: SECOND CHECK <u>MS</u> <u>07/01/11</u> <u>30</u>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/11	3	-2 parts are scrapped -dimension .119 <sup>.005</sup> -0.004 is under tolerance		- scrap + replace	J.L 07/01/11	A 07/01/11		M 07/01/11

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT
Job Number: 29647B		Part Number: D32782
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>HS/AM</i> 07-01-12 (30)
7.0	POWDER COATING 	POWDER COATING <i>102391</i>  Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>FL/YL</i> 07/01/16 (30)
8.0	QC3 	INSPECT POWDER COAT/ CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT <i>PL/16/16 (30)</i>
9.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>S418</i> <i>EP 07/01/16 (30) PL/16/16</i>
10.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*CD 07/01/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29647B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

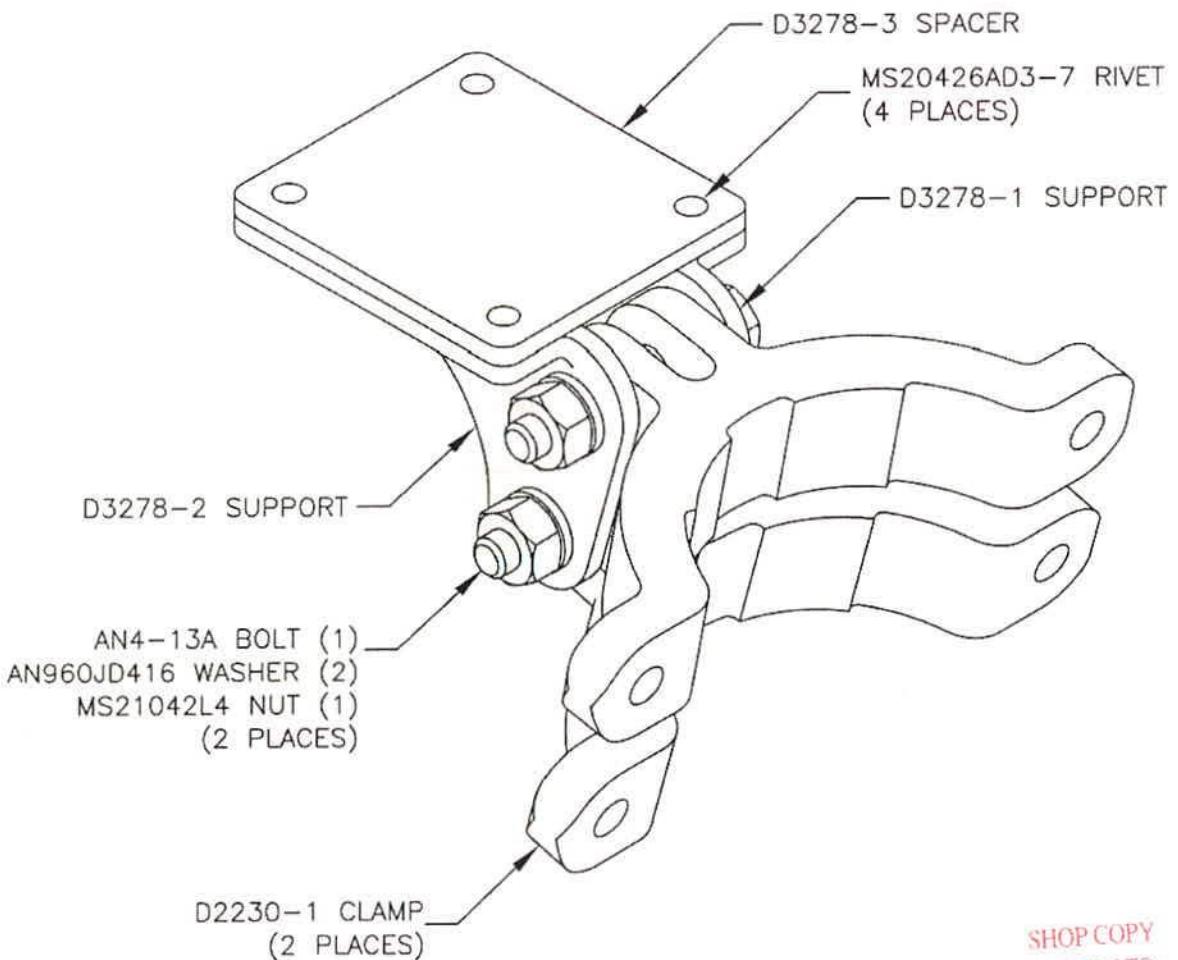
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø, 100"	✓			
0.359	+/-0.005	, 359"	✓			
0.017,609	+/-0.010	, 615"	✓			
0.250	+/-0.010	, 249"	✓			
1.480	+/-0.005	, 1,485"	✓			
R0.125	+/-0.010	R0,125"	✓			
0.119	+0.005/-0.004	, 120"	✓			
2.439	+/-0.010	2,439"	✓			
1.980	+/-0.010	1,982"	✓			
R0.130	+/-0.010	R0,130"	✓			
Ø0.257	+0.005/-0.000	Ø, 261"	✓			
R0.375	+/-0.010	R, 375"	✓			
0.875	+/-0.010	, 877"	✓			
0.500	+/-0.010	, 500"	✓			
R0.400	+/-0.010	R0,400"	✓			
1.720	+/-0.010	1,722"	✓			
R0.125	+/-0.010	R0,125"	✓			
0.125	+/-0.010	, 128"	✓			

Measured by: <i>J.F.</i>	Audited by: <i>E.</i>	Prototype Approval: N/A
Date: 07/01/09	Date: 07/01/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	<i>J.F.</i>

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

**RELEASED**  
05.04.04 *CH*D3278-041 SUPPORT ASSEMBLY

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WITHOUT NOTICE  
WORK ORDER  
NO. 29647B

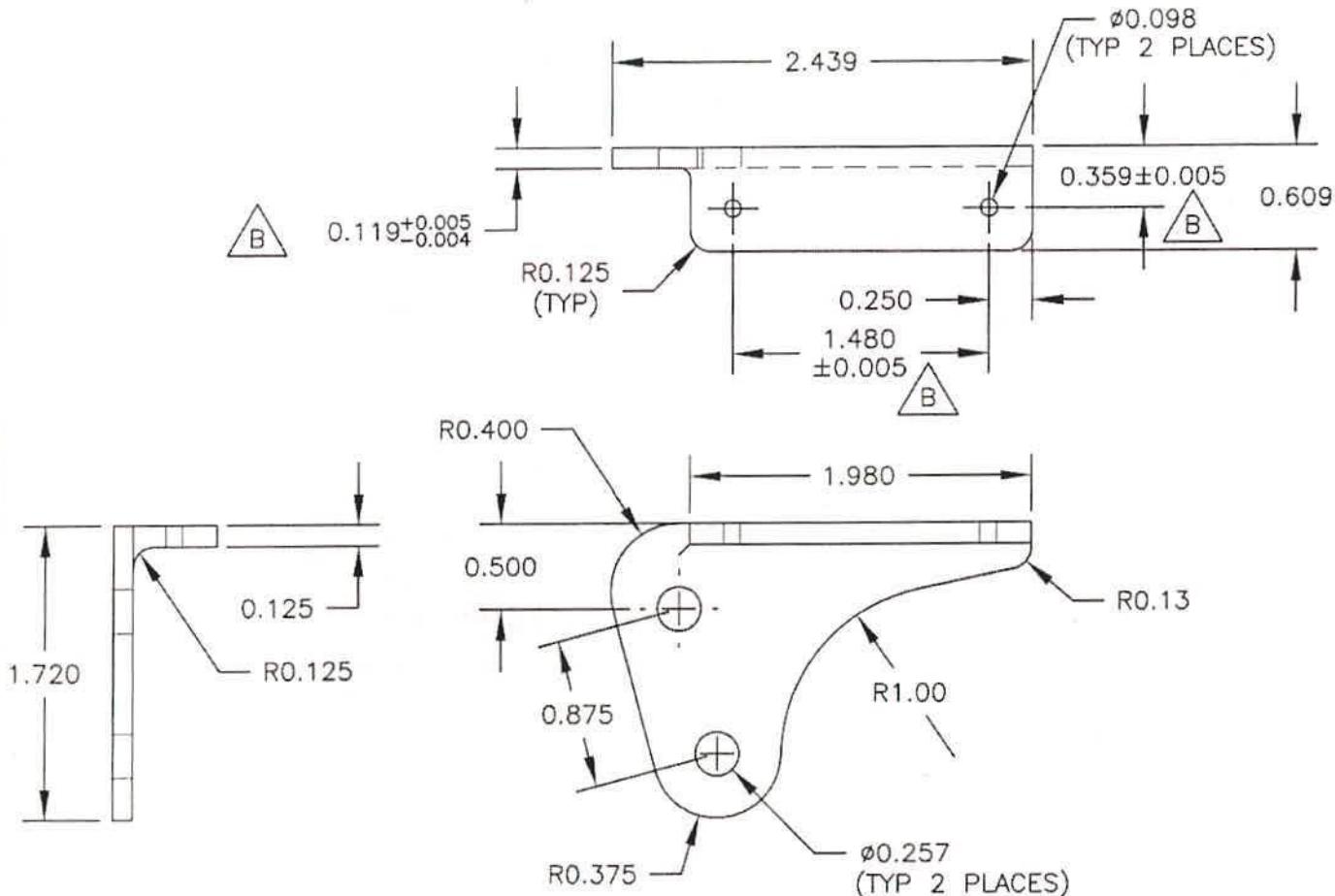
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31		REV. B SHEET 2 OF 3 TITLE SUPPORT ASSEMBLY SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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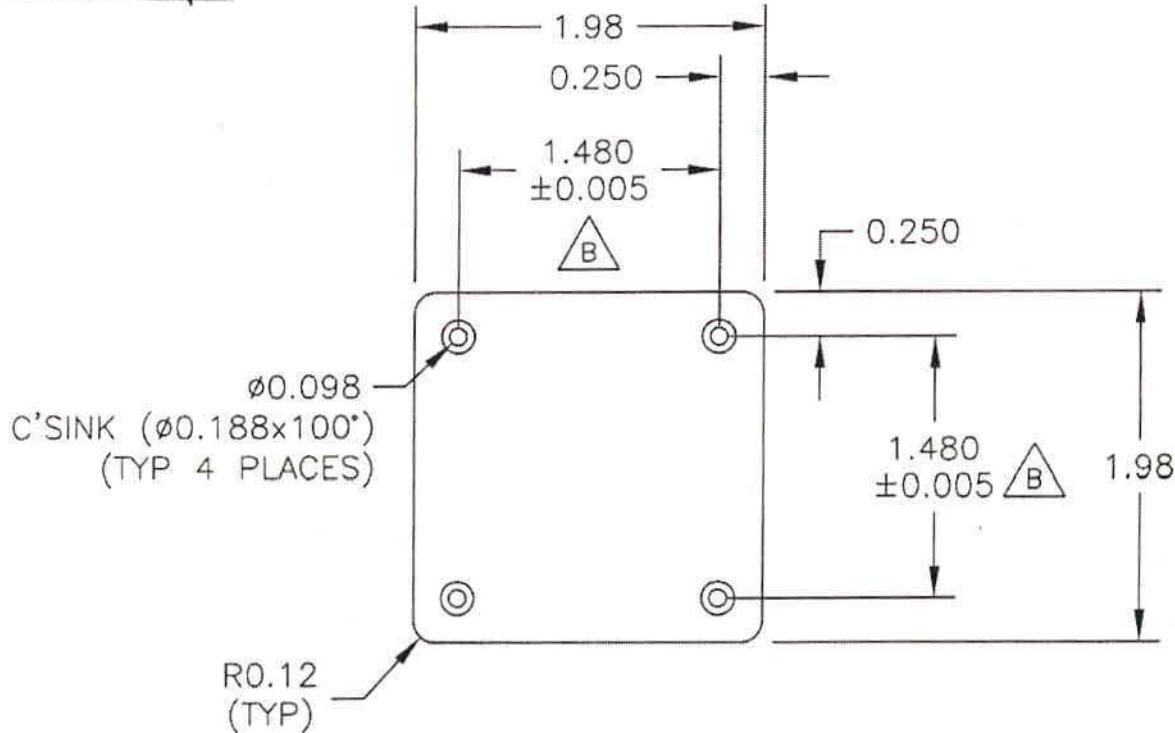
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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *MM*

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WORK ORDER  
NO *2964F7B*

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR *M-DELRIN-S*
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.